

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: 2015-53 Date Opened: 25 May 15 Title: FabricationAircraft OEM: Bell Aircraft Model: 206L/407 Product Type: Beams Product Model: N/A Quantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification  
Time Sheet (R&D)  
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
JR
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JR
JR

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
69830	3	Fwd Beam	JR
69831	3	Aft Beam	JR

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

1 set
N/A
N/A
JR

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

JR
N/A
N/A
N/A
N/A

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

JR
N/A
N/A

**Traveller**

Initial or N/A


Work performed by:

Print: J Rekve for M RekveSign: Jason Rekve

ICC / Dual Inspection performed by:

Print: Jason RekveSign: Jason Rekve

Work Order closed by:

Print: Jason RekveSign: Jason RekveSCA: AD01Date: 03-Jun-15SCA: AD01Date: 03-Jun-15SCA: AD01Date: 03-Jun-15

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

# MOUNTING BEAM FABRICATION – 69830/69831

## General

These instructions apply to mounting beams 69830-02 (forward) and 69831-02 (aft) for Bell 206L/407 low mounted cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

69830, Revision 3 – Forward Beam

69831, Revision 3 – Aft Beam

Note: Drawings 69830 and 69831 have configurations using HSS/mild steel and stainless steel. Only stainless steel beams are produced, HSS/mild steel was only used in early production.

Work Order: 2015-53

Batch Quantity: 1 FWD / 1 AFT

**Complete**  
(initial or SCA #)

Date Open: 25 MAY 2015

### 1. Beam Fabrication – 1x2 tubes – 69830-02 / 69831-02

ADD

- a. Cut 1 x 2 x 0.12 material as indicated on drawings.
  - i. 69830-02: 69830-13 (long tube), 69830-14 (down tube)
  - ii. 69831-02: 69831-13 (long tube), 69831-14 (corner tube), 69831-15 (down tube)
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder.
- d. Remove writing on tubes with acetone.
- e. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

### 2. CNC Machining – 69830-02 / 69831-02

JEFF JS

- a. Run CNC programs to machine keyways, slots and holes in component parts.
- b. De-burr keyways, slots and holes.
- c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

### 3. Beam Fabrication – Components – 69830-02 / 69831-02

ADD

Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.

- a. Shear and bend caps: 69830-19, 69830-20, 69831-20.
- b. Cut and turn 69830-15 bushings and 69830-11 guide tubes:
  - i. Cut stock to length + 0.03-0.06".
  - ii. Face one end flat @ 1000 RPM.
  - iii. De-burr outside with a file and inside with de-burring tool at 300 RPM.
  - iv. Setup stop and face other end to length @ 1000 RPM.
  - v. De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- c. Cut 69830-07 blocks.
- d. Record component POs / WOs on attached material list.



AD-05

## 4. Beam Welding – 69830-02 / 69831-02

- a. TIG weld 69830-11 guide tubes into 69830-14 and 69831-15 down tubes using ER308L rod, two places per down tube. Use jig to align guide tube to keyway and hole. Grind rosette welds flush.
- b. TIG weld 69830-15 bushings into 69830-13 and 69831-13 long tubes using ER308L rod, two places per tube, both sides. Ensure bushings protrude from correct side of beam. Refer to drawings.
- c. Forward beam (45 degree corners): TIG weld 69830-13 long tubes (from b) to 69830-14 down tubes (from a) using ER308L rod. Use corner vises to hold tubes square. Ensure top slot has sufficient clearance for basket fitting (96710-01 or Ancra 40088-14).
- d. Aft beam (22.5 degree corners): TIG weld 69831-13 long tubes (from b) to 69831-14 corner tubes and 69831-15 down tubes (from a) using ER308L rod. Use corner vises to hold tubes square. Ensure top slot has sufficient clearance for basket fitting (96710-01 or Ancra 40088-14).
- e. TIG weld components using ER308L rod:
  - i. 69830-16 strap to beam, centre on bushing.
  - ii. 69830-07 stops over bottom outboard keyway and top inboard keyway.
  - iii. 69830-19, 69830-20, 69831-20 caps.
- f. Record component and welding rod POs / WOs on attached material list.
- g. Tag in-progress parts for finishing.

## 5. Beam Finishing – 69830-02 / 69831-02

Note: straightening the beams is critical for ease of installation of the cargo basket.

- a. Straighten beams at strap using hydraulic press.
  - i. Set beam upside down on blocks as far apart as possible, locate ram over strap/bushing.
  - ii. Use a block to distribute press loads, about 2" wide
  - iii. Gradually work up to pressure required to make beam straight, usually more than 1000 psi is required. The same pressure generally works for beams from the same batch.
  - iv. Check for straight with a straight edge on bottom of tube. Ensure straight edge does not sit up on end cap.
- b. Straighten beams into plane using hydraulic press.
  - i. Check beams for plane by setting beam on a flat surface (welding table) on blocks. Use two blocks under long tube as far apart as possible. Attempt to slide block under end of down tube. Record direction and approximate distance to make block fit.
  - ii. Set beam on block under press ram, as close to corner at down tube as possible. Set the beam so that pushing down on the down tube will straighten the beam.
  - iii. Pressurize ram to 800 psi to hold beam.
  - iv. Clamp a snipe tube to down tube.
  - v. Push down on snipe tube. Note pressure on press for applied deflection. Similar deflections will require similar pressure.
  - vi. Check beams for plane, repeat steps ii-v if required.
- c. Break sharp edges off strap and stops using sanding disc on die-grinder.
- d. Tag in-progress parts for inspection.

dk

## MOUNTING BEAM FABRICATION – 69830/69831

Complete  
(initial or SCA #)

OK

### 6. Final Inspection – 69830-02 / 69831-02

To be completed by a different person than the previous steps.

- a. Inspect beams 69830-02 and 69831-02 for conformity to drawing.
- b. Tag in-progress parts ready for powder coating.

OK

### 7. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag in-progress parts ready for final assembly.

OK

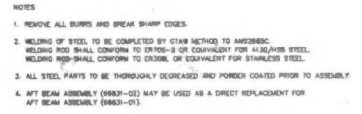
### 8. Final Assembly

To be completed after powder coating.

- a. Clear powder coat from stop pin hole(s) with 5/16 (#4) centre drill.
- b. Install #10-32 x 3" countersunk screw, 69830-21 stop, and 69830-23 spring into bottom guide with 69830-22 knob and MS21044C3 nut. Check for function.
- c. Optional - If cabin step is to be installed: Install #10-32 x 2.5" countersunk screw, 69830-21 stop, and 69830-23 spring into top guide with 69830-08 knob and MS21044C3 nut. Check for function.
- d. Adhere P/N placard to top surface of beam, between strap and end on top surface.
- e. Green tag completed beam assemblies and place into stock.



REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	BEAM MODIFIED TO ACCOMMODATE SLIDING DOOR	SLC	08/09/2008
2	BEAM MODIFIED FOR 2 KEYWAY ATTACHMENT	SLC	09/11/2008
3	KEYWAY ADDED FOR STEP INSTALLATION	SLC	10/07/2008



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**01 FORWARD BEAM ASSEMBLY**

**02 FORWARD BEAM ASSEMBLY**

**03 BUSHING**

**04 STRAP**

**05 BLOCK**

**06 CAP**

**07 GUIDE**

**08 STOP**

**09 KNOB**

**10 SPRING**

**11 KNOB**

**12 KNOB**

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**14 SPRING**

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**278 SPRING**

**279 KNOB**

**280 SPRING**

**281 KNOB**

**282 SPRING**

**283 KNOB**

**284 SPRING**

**285 KNOB**

**286 SPRING**

**287 KNOB**

**288 SPRING**

**289 KNOB**

<

Work Order: 3015-53Material Tracking Sheet  
Bell 206L / 407 Aft Mounting Beams

1 of 2

Date Open: 25 MAY 2015

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		<b>69831-02</b>	<b>Aft Beam Assembly</b>		
<b>Step 1</b>				<i>Fabrication</i>		
	. 1		69831-13	Tube	304 Stainless, 1x2x0.125 tube	<u>MOGO</u>
	. 1		69831-14	Tube	304 Stainless, 1x2x0.125 tube	<u>14060</u>
	. 1		69831-15	Tube	304 Stainless, 1x2x0.125 tube	<u>14060</u>
<b>Step 2</b>				<i>Machining</i>	<i>None</i>	
<b>Step 3</b>				<i>Fabrication</i>		
	. 2		69830-15	Bushing	316 Stainless, 5/8" x 0.120 tube	<u>12093</u>
	. 1		69830-16	Strap	304 Stainless, 0.105" Sheet	<u>PO# 13083</u>
	. 1		69830-17	Block	304 Stainless, 3/16" x 3/4" bar	<u>2014-49</u>
	. 1		69830-19	Cap	321 Stainless, 0.032" Sheet	<u>3021</u>
	. 1		69830-20	Cap	321 Stainless, 0.032" Sheet	<u>3021</u>
	. 1		69830-11	Guide	304 Stainless, 3/4" x 0.065" Rnd. Tube	<u>2015-14</u>
<b>Step 4</b>				<i>Welding</i>		
	. A/R		--	Welding Rod	ER308L	<u>PO# 14005</u>
<b>Step 5</b>				<i>Straightening</i>	<i>None</i>	
<b>Step 6</b>				<i>Inspection</i>	<i>None</i>	
<b>Step 7</b>				<i>Powder Coating</i>		
<b>Step 8</b>				<i>Final Assembly</i>		
Step 8.b.	. 1		69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	
	. 1		69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	
	. 1		69830-23	Spring	15mm x 70 mm Spring	
	. 1		69830-1032X3	#10-32 x 3 Screw	Stainless Steel, Commercial	
	. 1		MS21044C3	Nut		



Work Order: 2015-53

Material Tracking Sheet  
Bell 206L / 407 Aft Mounting Beams

2 of 2

Date Open: 25 MAY 2015

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8.c.	. 1		69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	
(optional)	. 1		69830-08	Knob	6061-T6 Aluminum, 1.25" Rod	
	. 1		69830-23	Spring	15mm x 70 mm Spring	
	. 1		69830-1032X2.5	#10-32 x 2.5 Screw	Stainless Steel, Commercial	
	. 1		MS21044C3	Nut		
Step 8.d.	. 1		--	P/N Placard	TZ Tape, 1/2", black on white	



Work Order: 2015-53Material Tracking Sheet  
Bell 206L/407 Forward Mounting Beams

1 of 2

Date Opened: 25 MAY 2015

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/NO
	<u>1</u>		<b>69830-02</b>	<b>Forward Beam Assembly</b>		
<b>Step 1</b>				<i>Fabrication</i>		
	. 1		69830-13	Tube	304 Stainless, 1x2x0.125 tube	<u>14060</u>
	. 1		69830-14	Tube	304 Stainless, 1x2x0.125 tube	<u>14060</u>
<b>Step 2</b>				<i>Machining</i>	<i>None</i>	
<b>Step 3</b>				<i>Fabrication</i>		
	. 2		69830-15	Bushing	316 Stainless, 5/8" x 0.120 tube	<u>120413</u>
	. 1		69830-16	Strap	304 Stainless, 0.105" Sheet	<u>PO# 13083</u>
	. 1		69830-17	Block	304 Stainless, 3/16" x 3/4" bar	<u>2014-49</u>
	. 1		69830-19	Cap	321 Stainless, 0.032" Sheet	<u>3021</u>
	. 1		69830-20	Cap	321 Stainless, 0.032" Sheet	<u>3021</u>
	. 1		69830-11	Guide	304 Stainless, 3/4" x 0.065" Rnd. Tube	<u>2015-14</u>
<b>Step 4</b>				<i>Welding</i>		
	. A/R		---	Welding Rod	ER308L	<u>PO# 14005</u>
<b>Step 5</b>				<i>Straightening</i>	<i>None</i>	
<b>Step 6</b>				<i>Inspection</i>	<i>None</i>	
<b>Step 7</b>				<i>Powder Coating</i>		
<b>Step 8</b>				<i>Final Assembly</i>		
Step 8.a.	. 1		69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	
	. 1		69830-22	Knob	6061-T6 Aluminum, 3/4" Rod	
	. 1		69830-23	Spring	15mm x 70 mm Spring	
	. 1		69830-1032X3	#10-32 x 3 Screw	Stainless Steel, Commercial	
	. 1		MS21044C3	Nut		

Work Order: 2015-53Material Tracking Sheet  
Bell 206L/407 Forward Mounting Beams

2 of 2

Date Opened: 25 MAY 2015


Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8.b.	. 1		69830-21	Stop	6061-T6 Aluminum, 5/8" Rod	
(optional)	. 1		69830-08	Knob	6061-T6 Aluminum, 1.25" Rod	
	. 1		69830-23	Spring	15mm x 70 mm Spring	
	. 1		69830-1032X2.5	#10-32 x 2.5 Screw	Stainless Steel, Commercial	
	. 1		MS21044C3	Nut		
Step 8.d.	. 1		--	P/N Placard	TZ Tape, 1/2", black on white	



**Description:** \_\_\_\_\_

[illegible]



1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No.
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2015-53</b>
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1	Forward Beam	69830-02	1	N/A	New
2	Aft Beam	69831-02	1		
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.					
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke – AD02</b>		13e. Date (dd/mmm/yyyy) <b>27 May 2015</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<b>Installer Responsibilities</b>					
This certificate does not constitute authority to install.					
Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.					
Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

WILDERNESS

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No.	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2015-53</b>	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1.	Forward Beam	69830-02	1	N/A	New	
2.	Aft Beam	69831-02	1			
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.  <input type="checkbox"/> Non approved design data specified in block 12.				<div style="border: 1px solid black; padding: 5px;">         14a. <input type="checkbox"/> CAR 571.10 Maintenance Release  <input type="checkbox"/> Other regulation specified in block 12           Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.       </div>		
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		<div style="border: 1px solid black; padding: 5px;">         14b. Signature   </div>		<div style="border: 1px solid black; padding: 5px;">         14c. Approved Organization Number   </div>
13d. Name <b>Jeff Clarke – AD02</b>		13e. Date (dd/mm/yyyy) <b>11 Sept 2015</b>		<div style="border: 1px solid black; padding: 5px;">         14d. Name   </div>		<div style="border: 1px solid black; padding: 5px;">         14e. Date (dd/mm/yyyy)   </div>
<b>Installer Responsibilities</b>						
<p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

FILED

1. Issuing Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2015-53</b>	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1	Forward Beam	69830-02	1	N/A	New	
2	Aft Beam	69831-02	1			
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.				<input type="checkbox"/> Other regulation specified in block 12		
<input type="checkbox"/> Non approved design data specified in block 12.				Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number
13d. Name <b>Jeff Clarke – AD02</b>		13e. Date (dd/mmm/yyyy) <b>27 May 2015</b>		14d. Name		14e. Date (dd/mmm/yyyy)


#### Installer Responsibilities

This certificate does not constitute authority to install.

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Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.




1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2015-54</b>	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	<b>Cargo Basket</b>	<b>69810-01</b>	<b>1</b>	<b>69801-81</b>	<b>New</b>	
12. Remarks <b>Modified with Lid Step and Front End Cutout IAW DCL704</b>						
13a. Certifies that the items identified above were manufactured in conformity to:				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.  <input type="checkbox"/> Non approved design data specified in block 12.				Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number
13d. Name <b>Jeff Clarke – AD02</b>		13e. Date (dd/mmm/yyyy) <b>27 May 2015</b>		14d. Name		14e. Date (dd/mmm/yyyy)

#### Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2013-57</b>	
3. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
1	Forward Beam	69830-02	1	N/A	New	
2	Aft Beam	69831-02	1			
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to:				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.						
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number
13d. Name <b>Jeff Clarke – AD02</b>		13e. Date (dd/mmm/yyyy) <b>27 May 2015</b>		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: 2015-54 Date Opened: 26 May 15 Title: AssemblyAircraft OEM: Bell Aircraft Model: 206L/407 Product Type: Cargo Basket Product Model: Standard Quantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification  
Time Sheet (R&D)  
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
JR
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JR
JR

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
69810	3	Basket	JR
69811	3	Body	JR
69812	3	Lid	JR
69827	2	Data Plate	JR

**Traveller**

Install walkway on lid  
Install lid on basket body  
Re-tap mounting lug holes and install mount lugs  
Install handle brackets  
Install handle  
Install lid prop  
Install data plate

Initial or N/A

JR
JR
JR
JR
JR
JR
JR

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

JR
N/A
N/A
N/A
N/A

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JR
N/A
N/A

Work performed by:

Print: Jason Rekve

Sign: \_\_\_\_\_

SCA: AD01Date: 26-May-15

ICC / Dual Inspection performed by:

Print: JEFF CLARKESign: Jeff ClarkeSCA: AD02Date: 26-May-15

Work Order closed by:

Print: Jason Rekve

Sign: \_\_\_\_\_

SCA: AD01Date: 26-May-15

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



2015-54

26-May-15

## **CARGO BASKET ASSEMBLY - COMMON**

### **General**

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407 – Right side only**

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

76610, Revision 0 – High Mounted Ski Basket

#### **Eurocopter AS350/AS355 – left or right**

77610, Revision 1 – Short Basket

76410, Revision 3 – Medium Basket (left or right)

78410, Revision 2 – Long Basket

94010, Revision 0 – Extra Large (ski) Basket

#### **Robinson R44 – left or right**

90610, Revision 0 – Standard Basket (left or right)

#### **Bell 206B – right side only**

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

#### **Bell 429 – right or left**

95911, Revision 0 – Standard Basket

#### **Bell Medium – left or right**

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

#### **MD600**

82811, Revision 0 – Standard Basket

#### **Options**

70405, Revision 3? – Lid Walkway

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

Work Order: 2015-54

Date Open: 26 May 15

OK

### 1. Lid Assembly

- a. Install lid bumpers on bottom.
  - i. Fill bumper holes with RTV silicone sealant.
  - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
  - i. Locate placard on bracket.
  - ii. Drill #30 through placard and bracket, using holes in placard.
  - iii. Remove placard and de-burr holes in placard and on bracket.
  - iv. Locate placard on bracket, and cleco in place.
  - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
  - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
  - ii. Pull tread plate from stock. Shear tread plate to length.
  - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
  - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
  - v. Mark and drill #30 holes:
    1. 0.25" from edge of tread plate, centre on cross members (0.38")
    2. 0.25" from edge of tread plate, middle of each walkway stringer
  - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
  - vii. De-burr holes in lid tubes.
  - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
  - ix. Set tread plate in place, secure with clecos if necessary.
  - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

OK

### 2. Body Assembly

- a. Install attachment fittings
  - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
  - ii. Run 3/8-24 tap into attachment lugs to clear threads.
  - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
  - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
    1. 90610 (Robinson R44) basket only:
      - a. Install 1 fitting 906?? in lower forward attachment lug only.
      - b. Install 3 96710-01 fittings in remaining locations.
  - v. Torque to ??

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
  - i. Locate 94621-01 Brace over aft cross tube cutout
  - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
  - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

## 3. Hinge Installation

- a. Prepare hinge.
  - i. Cut hinge to length:
    - 1. 776, 906 – 54"
    - 2. 751, 803 – 70"
    - 3. 698, 764, 945 – 72"
    - 4. 784 – 90"
    - 5. 940, 946, 959 – 95"
  - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
  - i. Locate hinge on basket (standard baskets)
    - 1. centre fore/aft
    - 2. 0.15" – 0.18" up from bottom edge
  - ii. Locate hinge on basket (extra wide baskets)
    - 1. centre fore/aft
    - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - v. Remove hinge and de-burr holes in hinge and basket rim.
  - vi. Cleco hinge to basket with 5/32 clecos.
  - vii. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
  - i. Locate lid on hinge (all baskets)
    - 1. center fore/aft
    - 2. 0.15" – 0.18" down from top edge
  - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - iv. Remove hinge and de-burr holes in hinge and lid rim.
  - v. Cleco lid to hinge with 5/32 clecos.
  - vi. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations



- d. Record PO of hinge and rivets on attached material tracking list.



#### 4. Install Handle

##### a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

##### b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

##### c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.



#### 5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)



### 6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
  - i. Bolts are tight
  - ii. Rivets are installed correctly
  - iii. Handle operates correctly
  - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

Work Order: 2015-54

Material Tracking Sheet  
Bell 206L / 407  
Standard Basket Assembly

1 of 2

Date Opened: 26-May-15

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			69810-01	<b>Cargo Basket Assembly</b>		
<b>Step 1</b>				<i>Lid Assembly</i>		<i>2015-36</i>
	. 1		69812-01	Basket Lid Assembly		
Step 1.a.	. . 3		49205-14	Bumper	Argus Industries Bumper	
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		69827-01	Placard	0.063 Sheet, 6061-T6 Aluminum	
	. . 4		CR3213-4-02	Cherry Rivet		<i>15031</i>
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	
	. . A/R		CR3213-4-02	Cherry Rivet		<i>15031</i>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	. 1		69811-01	Basket Body Assembly		<i>2015-38</i>
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	
	. . 8		NAS1149F0663P	Washer		
<b>Step 3</b>				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	72"	<i>14091</i>
	. 8		CR3523-5-02	Cherry Rivet		<i>15031</i>
	. A/R		CR3213-5-02	Cherry Rivet		<i>15031</i>
<b>Step 4</b>	. 1	84255	84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	<i>2015-42</i>
	. . 4		AN3-11A	Bolt		
	. . 8		NAS1149F0363P	Washer		
	. . 4		MS21044N3	Nut		



Work Order: \_\_\_\_\_

Material Tracking Sheet  
Bell 206L / 407  
Standard Basket Assembly

2 of 2

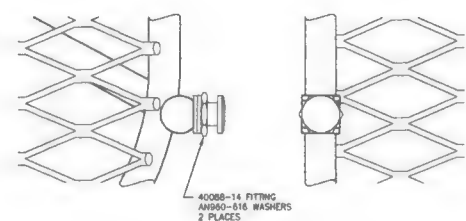
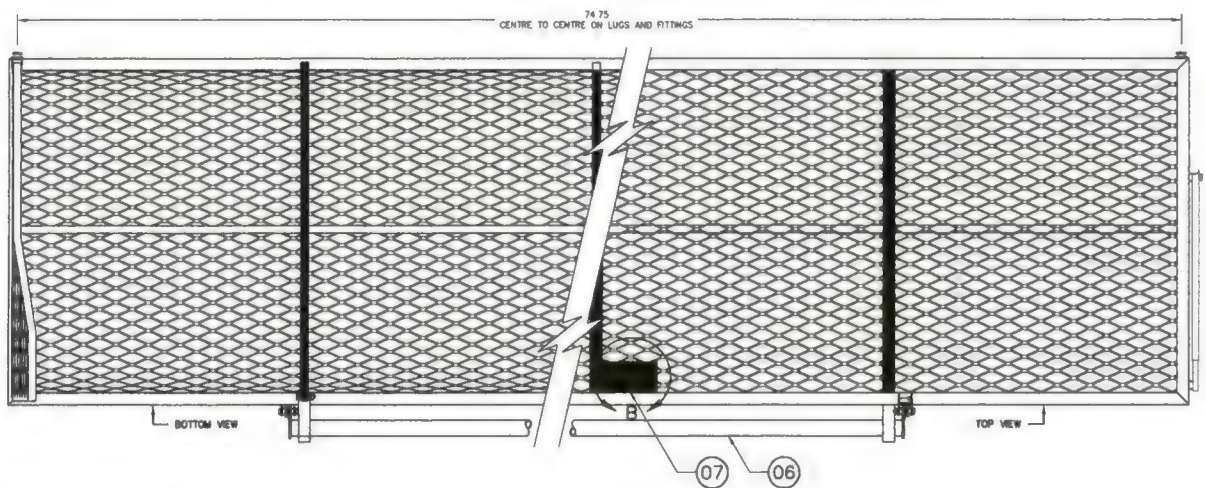
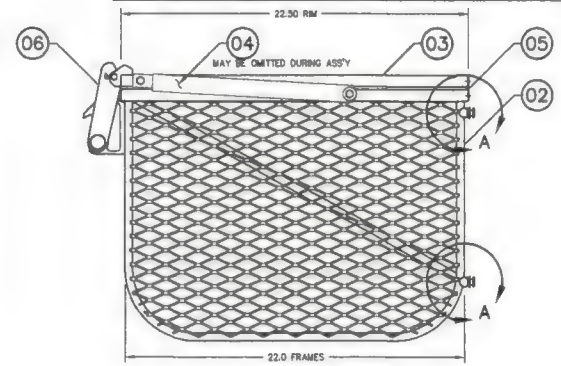
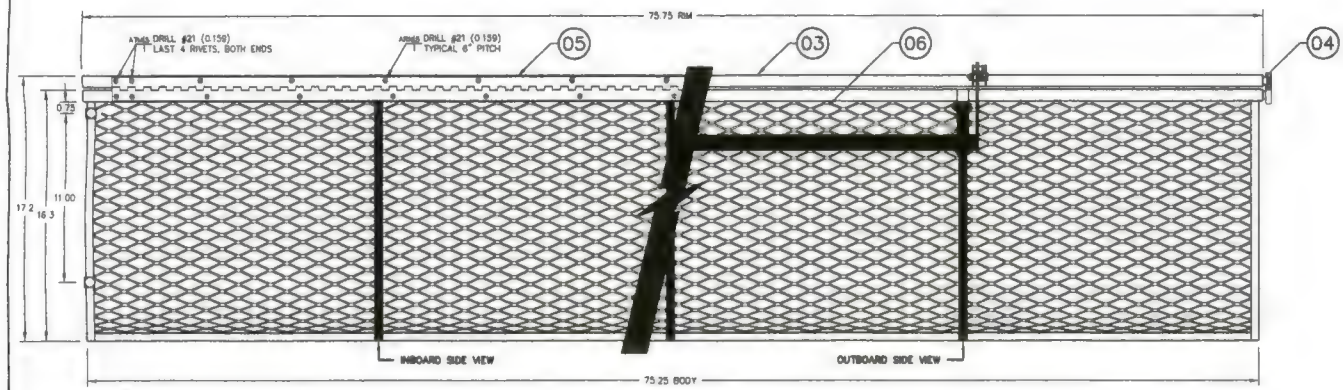
Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		15018
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	
	.. 2		AN3-12A	Bolt		
	.. 4		NAS1149F0363P	Washer		
	.. 2		MS21044N3	Nut		
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly		2014-63
	. 1		AN3-15A	Bolt		
	. 1		AN3-17A	Bolt		
	. 2		AN970-3	Washer		
	. 3		NAS1149F0363P	Washer		
	. 2		MS21044N3	Nut		
Step 6				Inspection	None	

2015-54

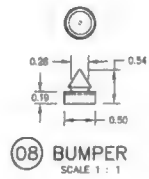
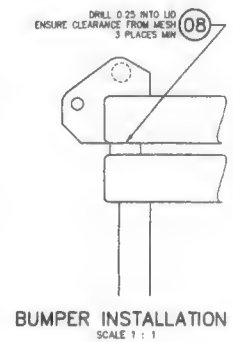
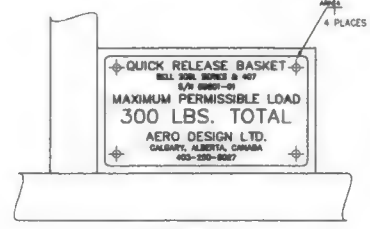
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THE DRAWING OF ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR SIMULATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE OR ABUSE OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	CHANGED LUGS	BJC	08/11/2006
2	PLACARD CHANGED, AFT END MODIFIED FOR CROSS TUBE CLEARANCE	BJC	21/05/2007
3	HINGE RIVETS CHANGED, HANDLE DETAILS CHANGED, PLACARD CHANGED	BJC	14/10/2011



NOTE:  
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

### 01 CARGO BASKET ASSEMBLY

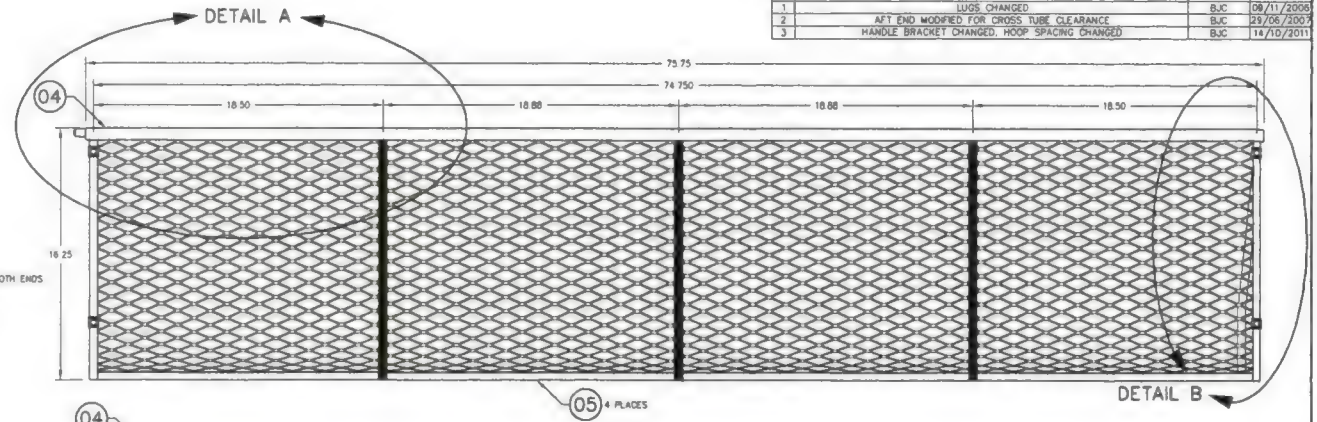
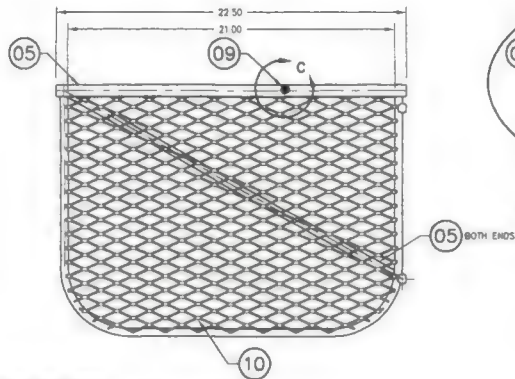


A/R	AMRD-016	WASHER	ANCHOR
4	40088-14	FITTING	
4	CR3213-4-02	CHERRY RIVET	
8	CR3523-5-02	CHERRY RIVET	
A/R	CR3213-5-02	CHERRY RIVET	
3	49805-14	08 BUMPER	
1	69811-01	07 PLACARD	
1	64355-01	06 HANDLE BAR INSTALLATION	
1	M52001P4	05 PLANO HINGE	
1	36280-01	04 BRACE ASSEMBLY	
1	69812-01	03 LUG ASSEMBLY	
1	69811-01	02 BASKET BODY ASSEMBLY	
1	69810-01	01 CARGO BASKET ASSEMBLY	
QTY	PART NO.	ITEM	DESCRIPTION

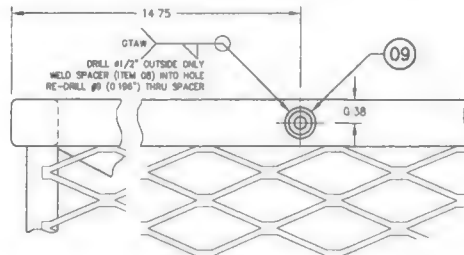
BASIC CODE		DASH NO. FOR DATE		APPROVALS		DATE	
REF: HAS 323		N=MFD HEAD NEAR SIDE F=MFD HEAD FAR SIDE		JEFF CLARKE		11 APR 2006	
C=COUNTERSUNK D=DMPL DIT=9 OF SHEETS TO BE DMPLD		DASH NO. FOR LENGTH		E. BURGH			
BASIC CODES: BJ = M520470AD BB = M520426AD ARH = CR3213 ATM = CR3523		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ANGLES X XXX ±0.010 ±1/2° X XX ±0.03 X X ±0.1		AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DBM 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 0R7 Tel: (403) 885-8887 Fax: (403) 885-8888 aerodesign@shaw.ca			
SCALE 1:1		DWG SIZE		DWG NO		REV	
SHEET 1 OF 1		A1		69810		3	



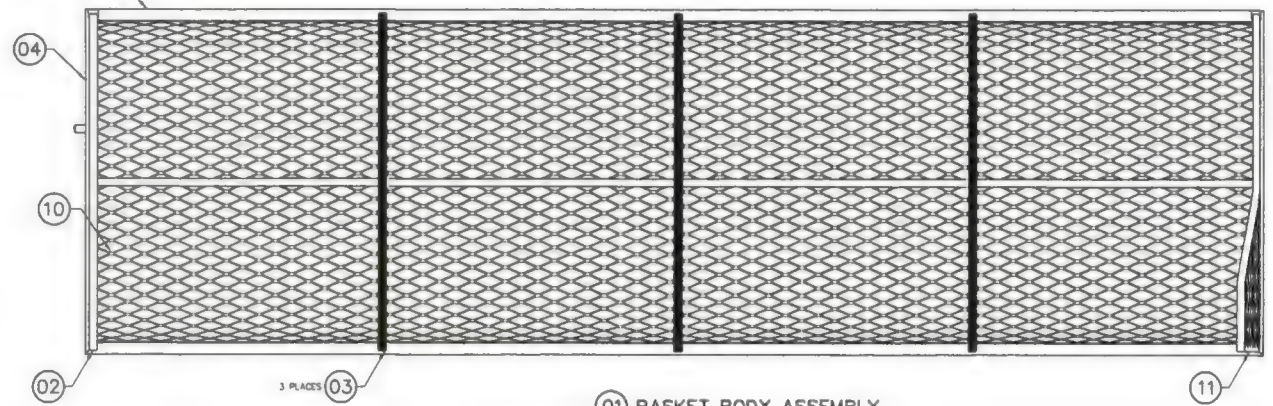
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	LUGS CHANGED	BUC	09/11/2008
2	AFT END MODIFIED FOR CROSS TUBE CLEARANCE	BUC	23/06/2009
3	HANDLE BRACKET CHANGED, HOOP SPACING CHANGED	BUC	14/10/2011



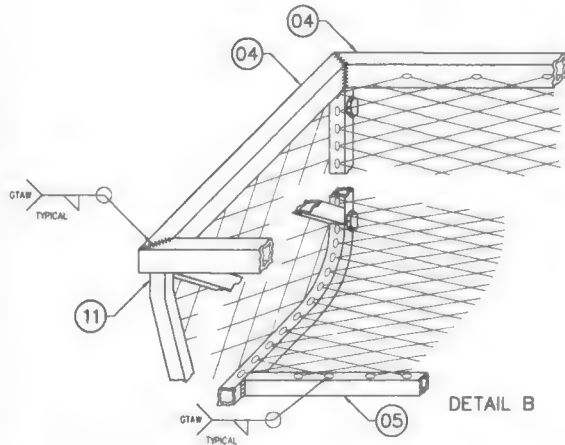
- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
  2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C
  3. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
  4. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD
  5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY



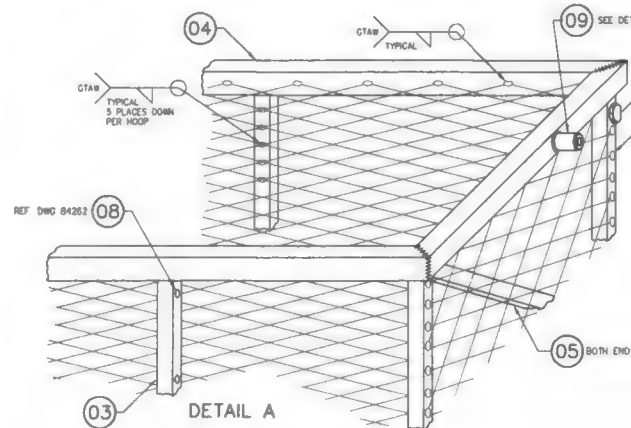
DETAIL C  
SCALE 1:1  
VIEW LOOKING AT FRONT RIM OF BASKET



01 BASKET BODY ASSEMBLY



DETAIL B



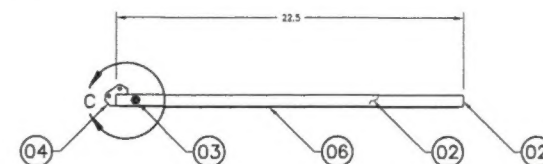
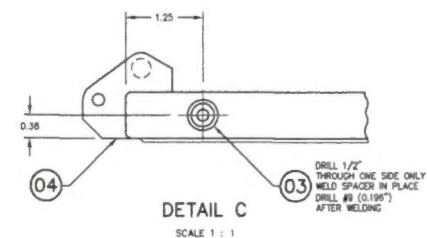
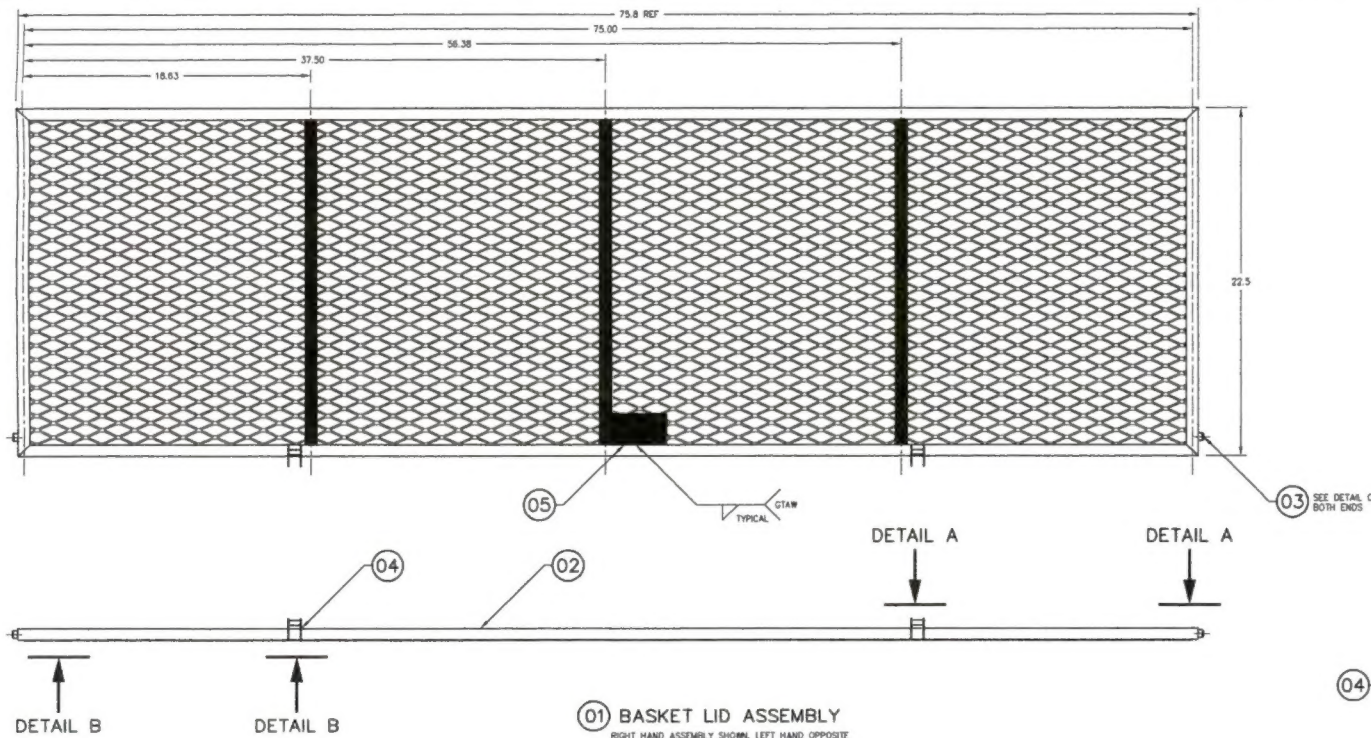
DETAIL A

QTY	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	59822-01	11	AFT END HOOP	STEEL	COMMERCIAL	
A/R	3/4-16F	10	MESH			
1	49215-01	09	SPACER			
1	54282-01	08	HANDLE BRACKET ASSEMBLY			
--	07	--	--			
--	06	--	--			
A/R	--	05	TUBE	4130 STEEL COND N	MIL-T-6736	0.5 X 0.035 SQ. TUBE
A/R	--	04	TUBE	4130 STEEL COND N	MIL-T-6736	0.75 X 0.035 SQ. TUBE
3	49210-02	03	HOOP			
1	59821-01	02	FORWARD END HOOP			
1	59811-01	01	BASKET BODY ASSEMBLY			

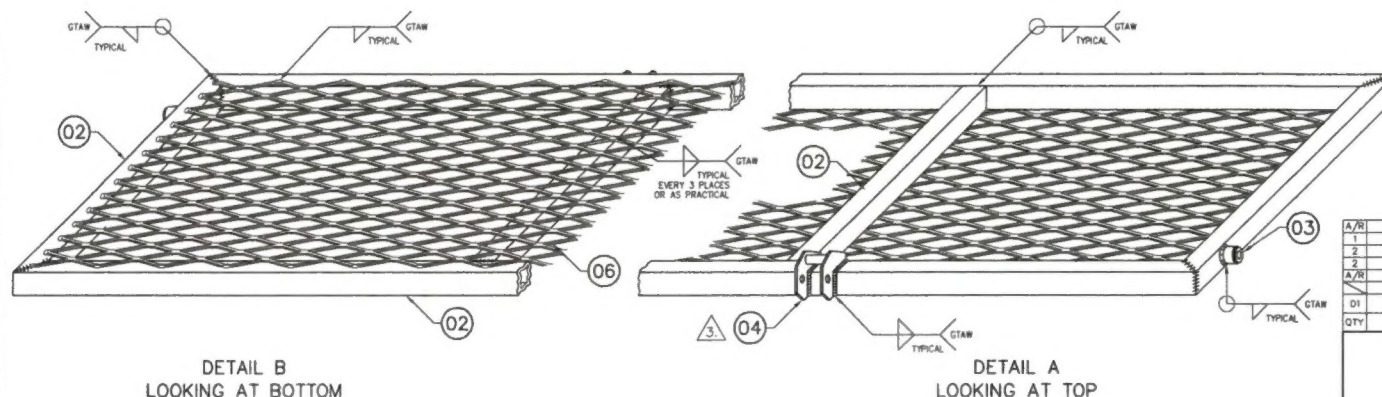
APPROVALS	DATE	AERO DESIGN LTD.	
DESIGNED BY: JEFF CLARKE	11 APR 2008	CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 890M	
CHECKED BY: E BURGON		2015 - 50TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 0G7	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON		BELL 206L, 407 QUICK RELEASE CARGO BASKET BASKET BODY ASSEMBLY	
DECIMALS	ANGLES	SCALE 1:4	DWG SIZE
X XXX ±0.010	±1/2"	A1	69811
X XX ±0.03			
X X ±0.1			
SHEET 1 OF 1		REV 3	



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL RELEASE		
1	CHANGED LOCATIONS OF SUPPORTS	RR	30 FEB 08
2	CHANGED HANDLE BRACKETS, ADD LEFT HAND CONFIGURATION	BJC	28 JAN 10
3	CHANGED LOCATION OF SUPPORTS, REMOVE SIDED CONFIGURATIONS	BJC	15 SEPT 11



- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
  2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO EN705-2 OR EQUIVALENT.
  3. INSTALL ITEM 6 (HANDLE BRACKET ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84262 TYP 2 PLACES.
  4. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
  5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLES PRIOR TO ASSEMBLY.



A/R	3/4-10F	06 MESH	MILD STEEL	COMMERCIAL		
1	38204-10	05 PLACARD BRACKET				
2	84262	04 UPPER HANDLE BRACKET ASSY				
2	49216-01	03 SPACER				
A/R	--	02 TUBE	4130 STEEL COND. N	MIL-Y-6736	0.75 X 0.035 SQR. TUBE	
69812-01	01	BASKET LID ASSEMBLY				
D1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

APPROVALS		DATE	AERO DESIGN LTD.			
DRAWN: JEFF CLARKE		11 APR 2006	CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 200M			
CHECKED: E. BURGIN			2013 - 30TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7			
			tel: (403) 250-8087 fax: (403) 250-8083 aerodesign@aerodesign.net			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			QUICK RELEASE CARGO BASKET BASKET LID ASSEMBLY			
DECIMALS			SCALE 1 : 4			
X.XXX ±0.010			DWG SIZE			
X.XX ±0.03			DWG NO.			
X.X ±0.1			REV.			
			SHEET 1 OF 1			
			A1 69812 3			



# NOTICE

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	CHANGED TO ENGRAVED ALUMINUM	BJC	19 JUNE 2007
2	INCREASED LOAD	BJC	26 OCT 2011

## NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:  
"QUICK RELEASE BASKET" - 0.125 HIGH  
"BELL 206L SERIES & 407" - 0.080 HIGH  
"S/N 69801-XX" - 0.080 HIGH  
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH  
"300 LBS. TOTAL" - 0.200 HIGH  
"AERO DESIGN LTD." - 0.125 HIGH  
"CALGARY, ALBERTA, CANADA" - 0.080 HIGH  
"403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)  
4 PLACES



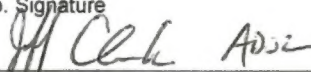
01 PLACARD

1	69827-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
			APPROVALS	DATE	<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net	
			DRAWN: JEFF CLARKE	24 APR 2006		
			CHECKED: E. BURGOIN			
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		BELL 206L SERIES AND 407 QUICK RELEASE CARGO BASKET PLACARD	
			SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
			SHEET 1 OF 1	A4	69827	2



WO# 2015-54

[illegible]

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No.	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2015-54</b>	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	<b>Cargo Basket</b>	<b>69810-01</b>	<b>1</b>	<b>69801-81</b>	<b>New</b>	
12. Remarks <b>Modified with Lid Step and Front End Cutout IAW DCL704</b>						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number
13d. Name <b>Jeff Clarke – AD02</b>		13e. Date (dd/mmm/yyyy) <b>27 May 2015</b>		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

WILDERNESS